

5/44

DART AEROSPACE LTD	Work Order:	24524
Description: Seat Modification kit	Part Number:	D350-689-015
Dwg:	Qty:	1
Ref: DSI 9222 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																								
1	DC	Issue Traveler	AK	05.10.12	1																																																								
2	DC	Photocopy bluefile and create labels per PPP D350-689-015 CHG001 PER DSI 9222 04.04.01 HRF WK 4248																																																											
3	GA	Cut (1) blank 18.00" as per Dwg D3033 from D3033-144 extrusion. <i>Batch:</i>																																																											
4	FP	Chemical Conversion Coat D3033-1 as per QSI 005 4.1	N/A																																																										
5	QC3	Inspect work to Step 4																																																											
6	KP	Pick: Packing Kit (Note: D3033-1 is made from material D3033-144 and is not on the BOM) <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D3029-1</td> <td>Spring</td> <td>B22346</td> </tr> <tr> <td>2</td> <td>D3030-1</td> <td>Lock</td> <td>B22350</td> </tr> <tr> <td>1</td> <td>D3033-1</td> <td>Seat Track</td> <td>B24592</td> </tr> <tr> <td>4</td> <td>D3059-1</td> <td>Stud</td> <td>B22022</td> </tr> <tr> <td>4</td> <td>D3060-1</td> <td>Bushing</td> <td>B22348</td> </tr> <tr> <td>4</td> <td>D3061-1</td> <td>Radius Block</td> <td>B22349</td> </tr> <tr> <td>3</td> <td>AN960JD10L</td> <td>Washer</td> <td>M16612</td> </tr> <tr> <td>4</td> <td>AN960JD516</td> <td>Washer</td> <td>M18100</td> </tr> <tr> <td>8</td> <td>MS20426AD3-6</td> <td>Rivet</td> <td>M16527</td> </tr> <tr> <td>4</td> <td>MS21042L5</td> <td>Nut (or -5)</td> <td>M17694</td> </tr> <tr> <td>4</td> <td>MS21059L3</td> <td>Nut Plate</td> <td>M12240</td> </tr> <tr> <td>1</td> <td>MS24693S273</td> <td>Screw</td> <td>M1497</td> </tr> <tr> <td>1</td> <td>MS27039-1-10</td> <td>Screw</td> <td>M18836</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	D3029-1	Spring	B22346	2	D3030-1	Lock	B22350	1	D3033-1	Seat Track	B24592	4	D3059-1	Stud	B22022	4	D3060-1	Bushing	B22348	4	D3061-1	Radius Block	B22349	3	AN960JD10L	Washer	M16612	4	AN960JD516	Washer	M18100	8	MS20426AD3-6	Rivet	M16527	4	MS21042L5	Nut (or -5)	M17694	4	MS21059L3	Nut Plate	M12240	1	MS24693S273	Screw	M1497	1	MS27039-1-10	Screw	M18836			
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7	QC4	Inspect Kit 100% for Completeness on the W/O	PO	05/11/02	1																																																								
8	PK	Identify and pack for shipping as per PPP D350-689-015 Rev A	CL	05/11/17	1																																																								
9	AC	Cost / part: 3014.25	SAC	05-11-21	1																																																								
10	DC	Close W/O 348.77 Inspect Level 21	CL	05/11/21	1																																																								

Rev	Date	Change	Revised By	Approved
A	04.03.25	New Issue	KJ/RF	

RELEASED
04.03.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *LD* Date: 05/11/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 11, 2005
11:50 am

Work Order No : 0024524
Project Name : D350-689-015
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : *D350-689-015
Description : Seat Modification Kit
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 10-11-05
Est Finish Date : 11-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Friday, 11/18/2005 9:29:53 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SEAT MOD KIT
Job Number : 24524	
Estimate Number : 10715	
P.O. Number :	Part Number : D350689015
This Issue : 11/18/2005 S.O. No. :	Drawing Number : D3033 REV A1
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run :	Material :
Written By :	Due Date : 11/25/2005 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 04.03.25 New Issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile per DSI 9222 and create labels per PPP D350-689-015 CHG001

2.0	D3033144	Seat Track
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3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Cut (1) blank 18.00" as per Dwg D3033 from D3033-144 extrusion.

Deburr blank and identify as D3033-1.

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

Date: Friday, 11/18/2005 9:29:53 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT MOD KIT

Job Number: 24524

Part Number: D350689015

Job Number:



Seq. #:	Machine Or Operation:	Description :
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7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

8.0	D30291	Spring
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9.0	D30301	Lock
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10.0	D30591	Stud
------	--------	------

11.0	D30601	Bushing
------	--------	---------

12.0	D30611	Radius Block
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13.0	AN960JD10L	Washer
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14.0	AN960JD516	Washer
------	------------	--------

15.0	MS20426AD36	Rivet
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16.0	MS21042L5	Nut
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17.0	MS21059L3	Nut Plate
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18.0	MS24693S273	Screw
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19.0	MS27039110	Screw
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20.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

21.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP d350-689-015

Location: _____

PPP Rev: _____

22.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Saturday, 11/19/2005 11:54:30 AM

User: Linda Lacelle

INVENTORY ITEMS PICKED FOR SLIP NUMBER 63

Project No. :
 Customer : Dart Helicopters Services
 Part Number : D350689015
 Job Number : 24524

Drawing Number : D3033 REV A1
 Drawing Name : SEAT MOD KIT
 Due Date : / /
 Qty : 1
 Slip # : 63

		Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
8.0	D30291							
	Spring							
	Available	10.00	MAIN		22346	2.00		2.0000 Each
9.0	D30301							
	Lock							
	Available		MAIN		22350	2.00		2.0000 Each
10.0	D30591							
	Stud							
	Available	26.00	MAIN		22347	4.00		4.0000 Each
11.0	D30601							
	Bushing							
	Available	11.00	MAIN		22348	4.00		3.0000 Each
			MAIN		24725	4.00		1.0000
12.0	D30611							
	Radius Block							
	Available	46.00	MAIN		22349	4.00		4.0000 Each
13.0	AN960JD10L							
	Washer							
	Available	7268.00	MAIN		16612	3.00		3.0000 Each
14.0	AN960JD516							
	Washer							
	Available	1845.00	MAIN		18100	4.00		4.0000 Each
15.0	MS20426AD36							
	Rivet							
	Available	2652.00	MAIN		16527	8.00		8.0000 Each
16.0	MS21042L5							
	Nut							
	Available	868.00	MAIN		17694	4.00		4.0000 Each
17.0	MS21059L3							
	Nut Plate							
	Available	611.00	MAIN		12240	4.00		4.0000 Each
18.0	MS24693S273							
	Screw							
	Available	327.00	MAIN		1495	1.00		1.0000 Each
19.0	MS27039110							
	Screw							
	Available	920.00	MAIN		18836	1.00		1.0000 Each